

Date: Tuesday, 24/06/2008 10:58:30 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MIRROR BRACKET
 Job Number : 40008
 Estimate Number : 10245
 P.O. Number :
 This Issue : 24/06/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2010101
 Drawing Number : D2010 REVD
 Project Number : N/A
 First Issue : 24/06/2008 Type : SMALL /MED FAB Drawing Revision : D
 Material :
 Previous Run : 39920 Due Date : 07/07/2008 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : JUL 08 10 24
 Comment : Est:E 02.06.25 Added Rev. C1 KJ/RF
 Est Rev:F 07-08-015 Now on WaterJet Verified By:EC
 Est Rev:G 08-05-27 as per ECN1195P DD verified by:EC
 Est Rev:H 08-06-20 rev.D as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



8



Comment: Qty.: 0.3646 sf(s)/Unit Total : 7.2912 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: 108415 B 8-7-3

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2010-101

Dwg Rev: D

Prog Rev: D

B 8-7-3

(21)

2-Deburr if necessary

B 8-7-3

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-7-3



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/07/03

(21)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

a/a Done at step #2.2

S 08/07/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 10:58:31 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 40008

Part Number: D2010101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



PRO →

Comment: NC BRAKE

Form as per Dwg D2010

S/S 08/07/09 (21)

8
7.0
9.0

FE032EF

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Inserts

Pick:

Qty Part Number

Description

Batch

4

FE-032-EF

Insert

M10 8313 22X

M108046 62X

B 08/7/10

8
8.0
10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install fasteners per Dwg D2010

08/07/11

(21)

8
9.0
11

QC5

INSPECT WORK TO CURRENT STEP



counted

Comment: INSPECT WORK TO CURRENT STEP

08/07/11 (420)

8
10.0
7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m102316

(21)

START TIME:

11:30
12:00
12:00

OVEN TEMPERATURE:

FINISH TIME:

08/07/09

8
11.0
8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08/07/10 (21) counted

8
12.0
12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 224

08/07/11 (421)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/07/03	#	ADD QC # 5 after Bending	S	08/07/07	(21)	E	S 08/07/03
	6.1						
	6.2	Chemical coat as per QS 7005	/BR	08-07-08	(21)	E	S 08/07/03

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 10:58:31 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 40008

Part Number: D2010101

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

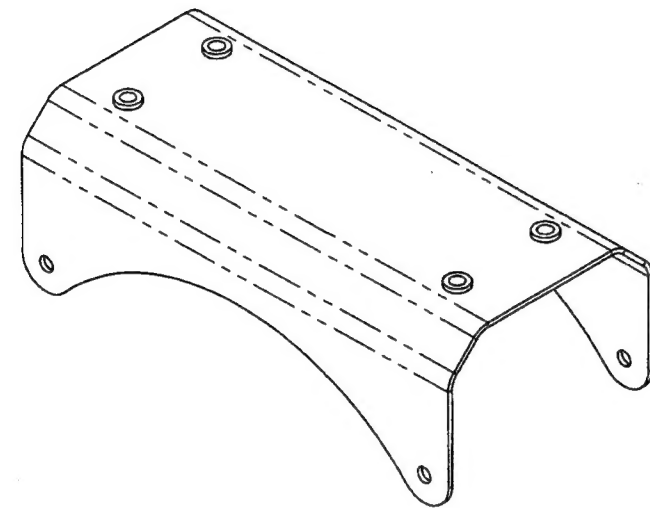
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

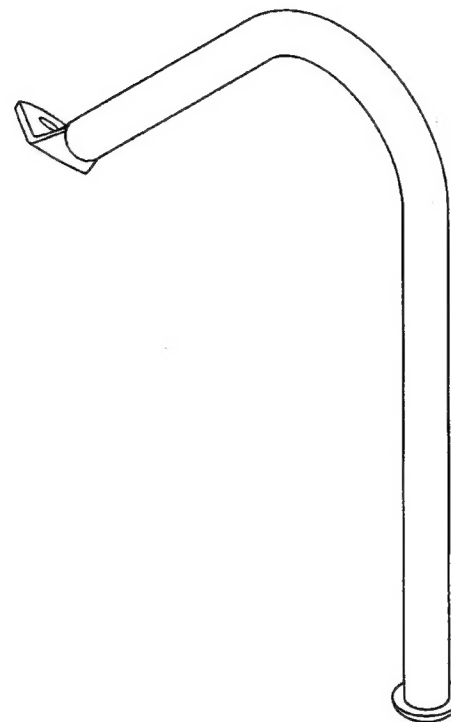
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

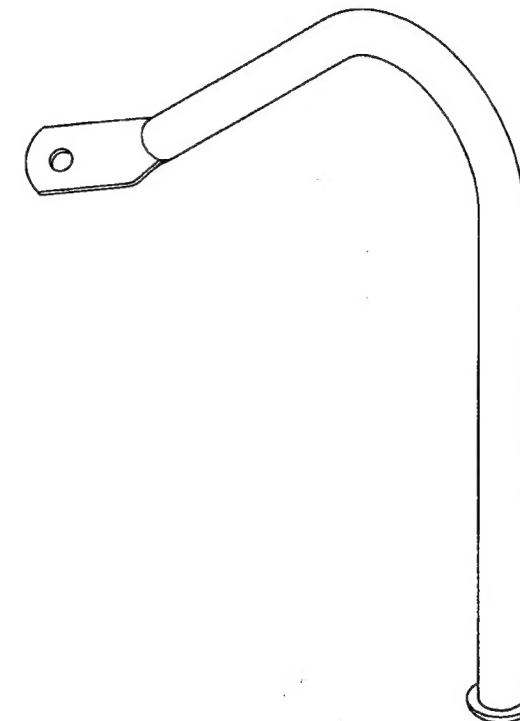
NOTE: Date & initial all entries



D2010-101 MIRROR BRACKET



D2010-103 ARM



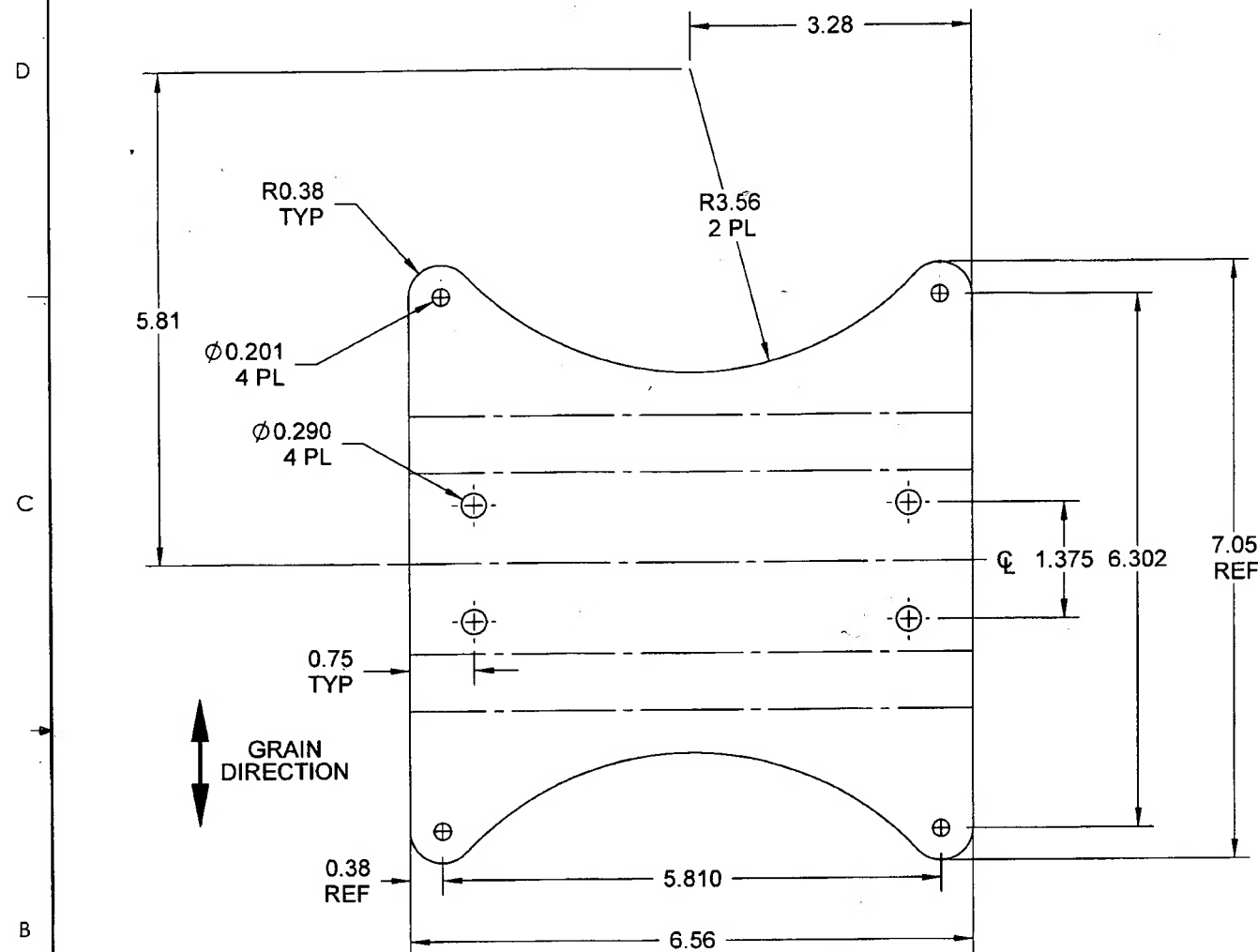
D2010-104 ARM

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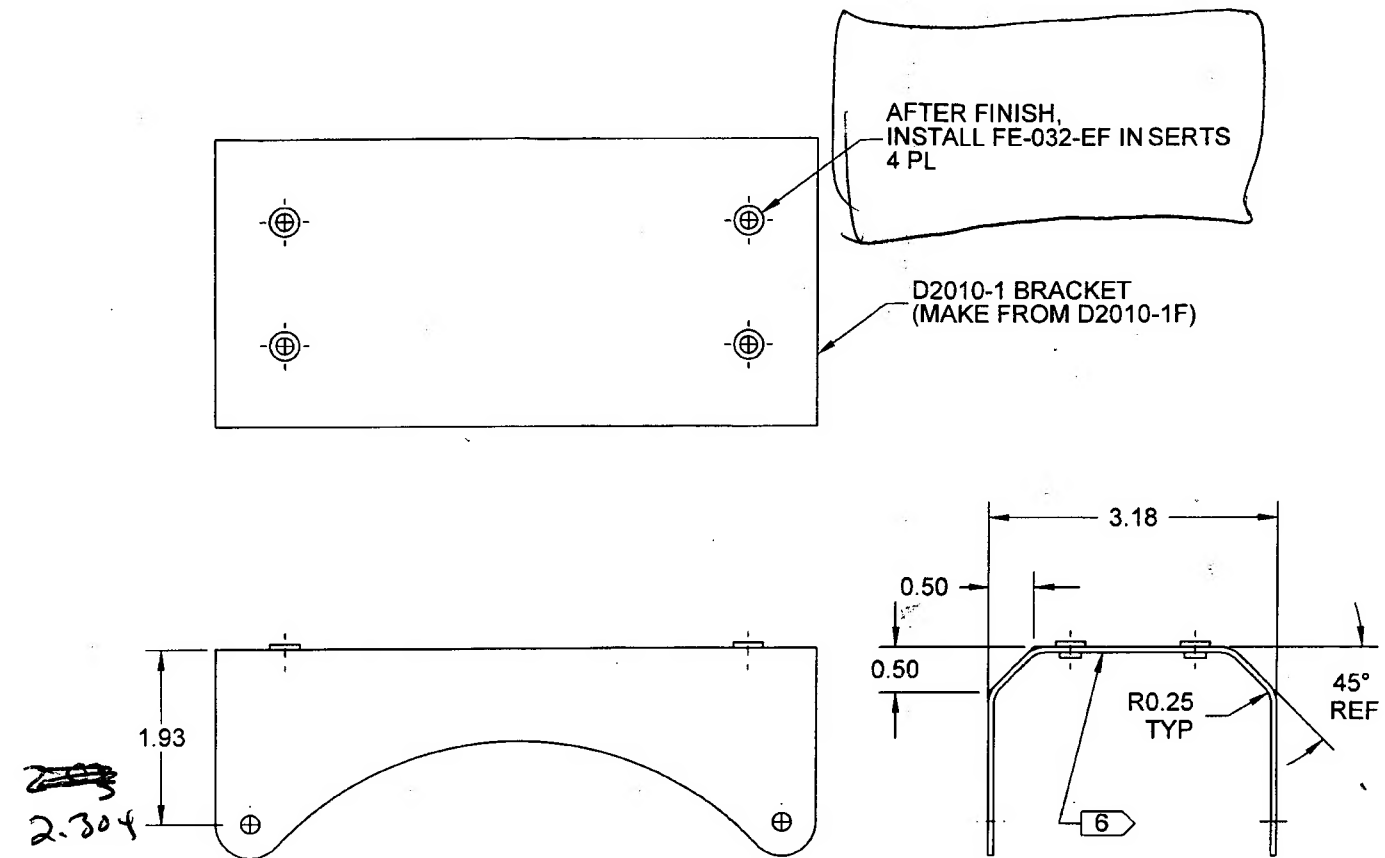
RELEASED
08.06.10

D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON; TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JB		
CHECKED	JB	DRAWING NO.	REV. D
MFG. APPR.	JB	D2010	SHEET 1 OF 4
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	MIRROR BRACKET	NTS
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QTY -101	P/N	DESCRIPTION
X	D2010-101	MIRROR BRACKET
1	D2010-1	BRACKET
4	FE-032-EF	INSERT








D2010-1F FLAT PATTERN



D2010-101 MIRROR BRACKET

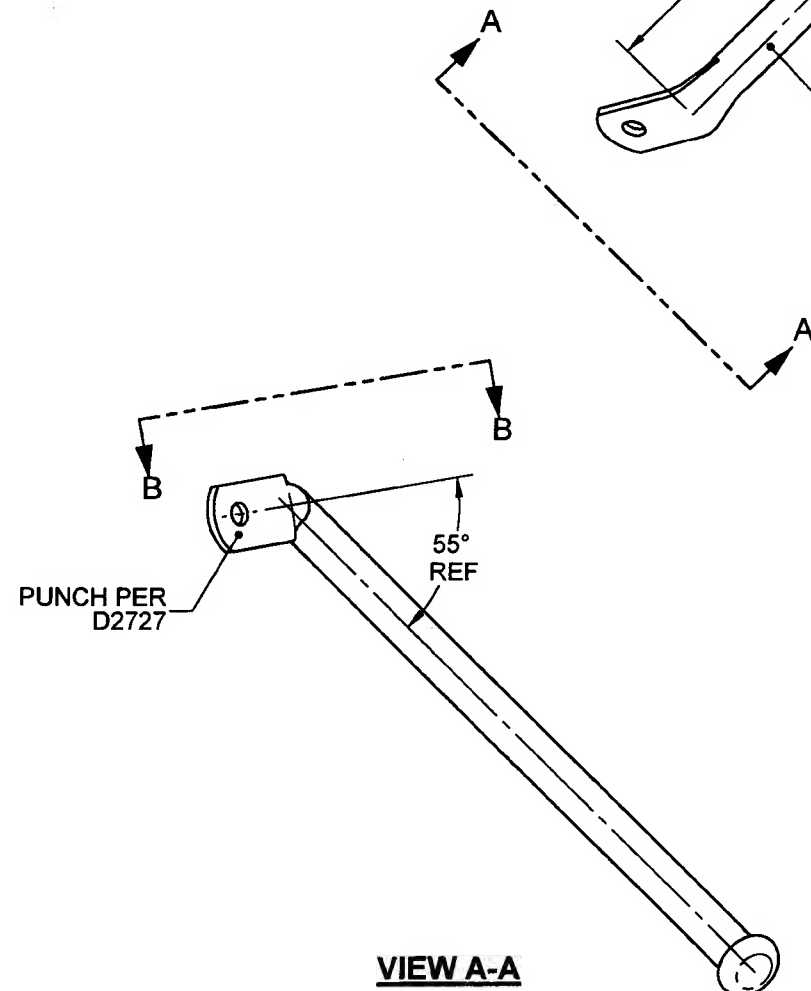
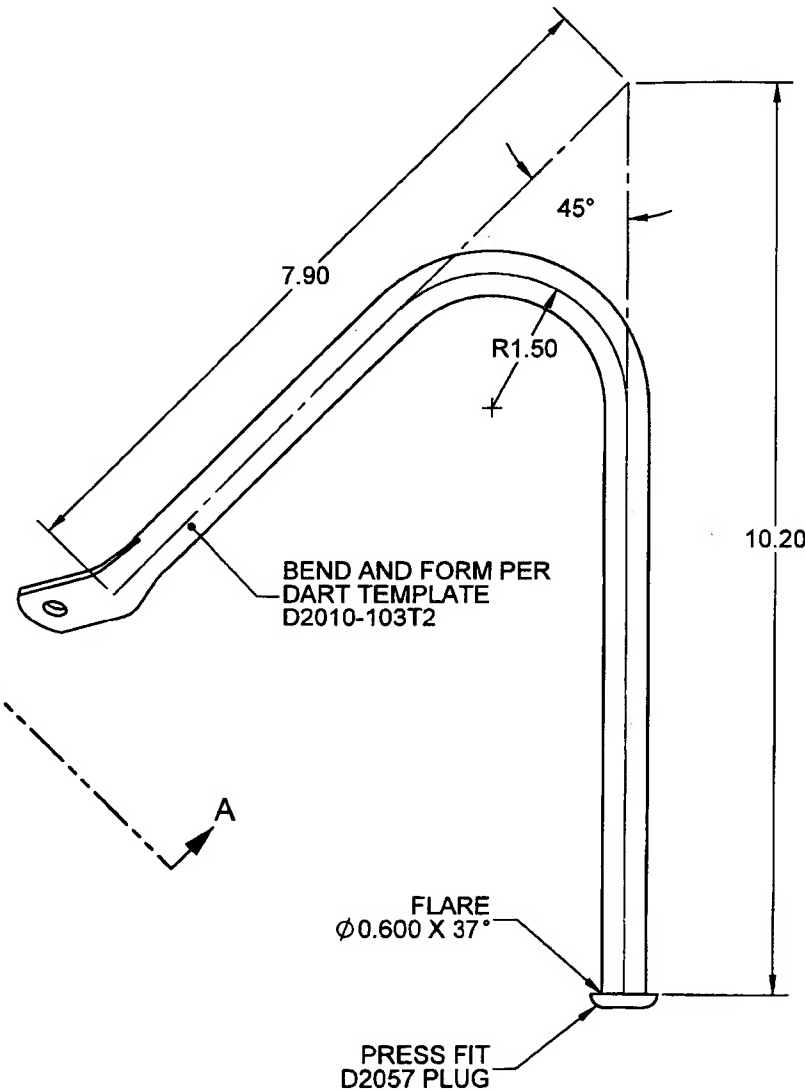
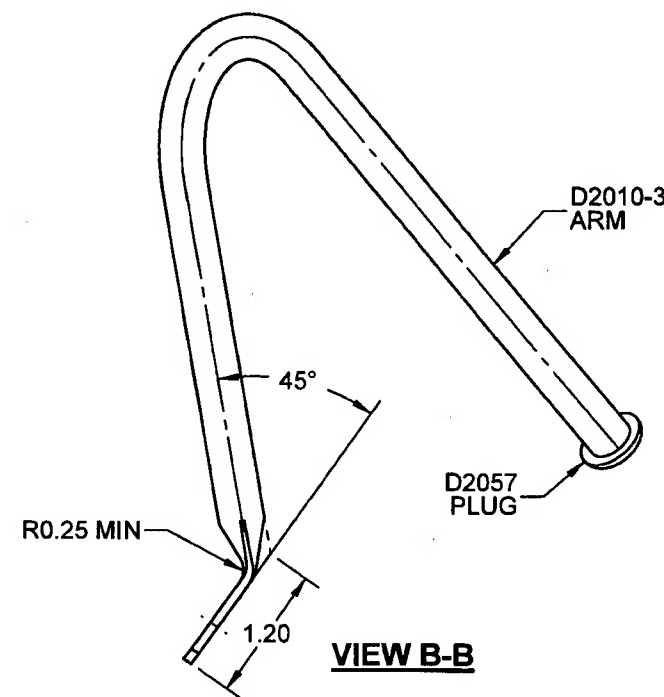
- NOTES:**
- 1) MATERIAL: D2010-1F: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-101" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
 - 7) WEIGHT: 0.23 lbs

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58-0619/11

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QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG



D2010-103 ARM

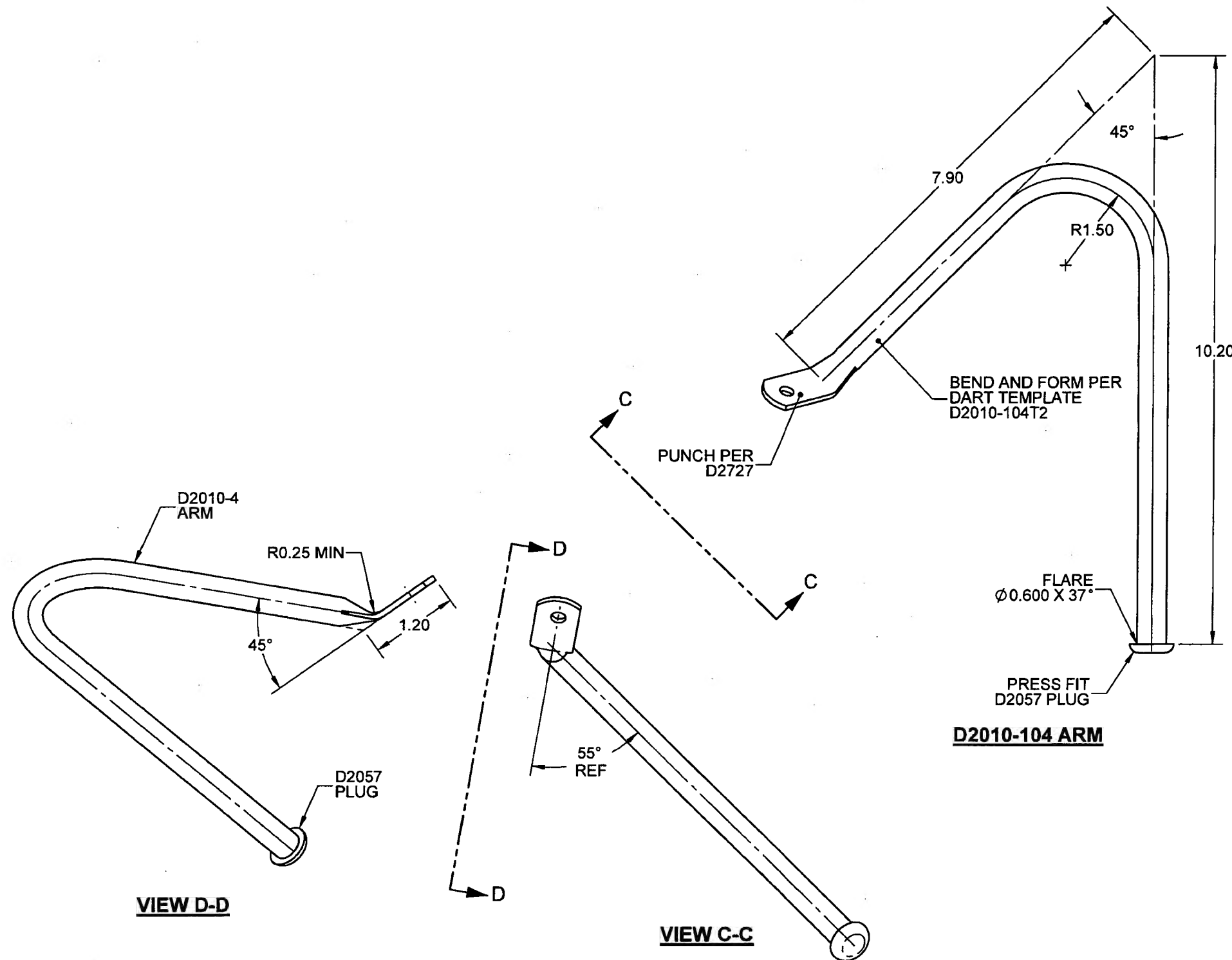
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- NOTES:**
- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING, $\varnothing 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049) Δ
 - 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

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QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG



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08-06-10

- NOTES:
 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING, $\varnothing 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049) Δ
 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING WHITE FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.34 lbs

DESIGN	JB	DART AEROSPACE LTD	
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MFG. APPR.		D2010	SHEET 4 OF 4
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